

Date: Thursday, 11/29/2007 11:06:55 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD	SPJ + 6
Job Number	36040 -1			08/01/02
Estimate Number	12712			
P.O. Number	N/A	Part Number	D35371	
This Issue	11/29/2007	S.O. No.	N/A	D3537 REV C
Prsht Rev.	NC			N/A
First Issue	N/A	Type	SMALL /MED FAB	C
Previous Run	35696			Material N/A
Written By				Due Date 12/10/2007
Checked & Approved By				Qty: 100 Um: Each
Comment	Est Rev:A	New Issue 07-02-14	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 8.5104
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s) M304S16GA .063" 304 SS SHEET Batch: 105997 LB 07-12-6
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C LB 07-12-6 Prog Rev: C
		108
		2-Deburr if necessary LB 07-12-6
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE LB 07-12-6
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1
		SB 07/12/11 108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/12/06	# 2.0	6 parts have a dim. of 3.600 instead of 3.625. PL. water jet cut to small.	PH 07.12.06 por QSE 042	Parts are acceptable this on time only. Acceptable edge distance remains based on E/D=1.5	B 07-12-06	✓ 9/12/06	PH 07.12.06 por QSE 042	✓ 9/12/06

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36040
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

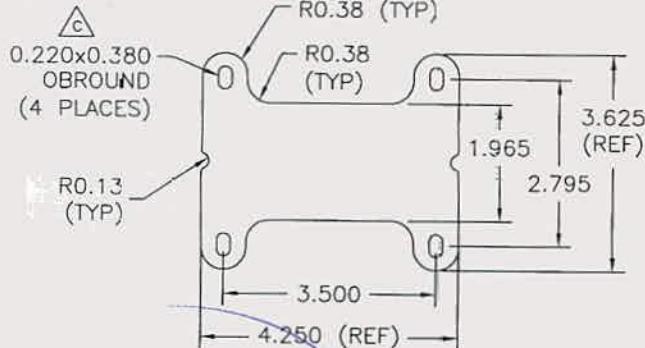
X First Article Prototype

Measured by: <u>WB</u>	Audited by: <u>d</u>	Prototype Approval: N/A
Date: <u>07-12-16</u>	Date: <u>7/17/16</u>	Date: N/A

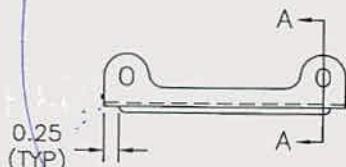
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	



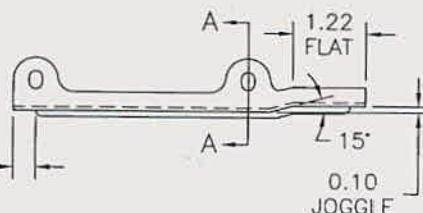
D3537-1F FLAT PATTERN



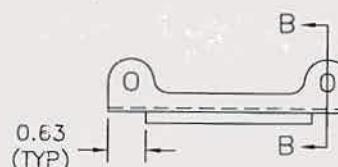
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

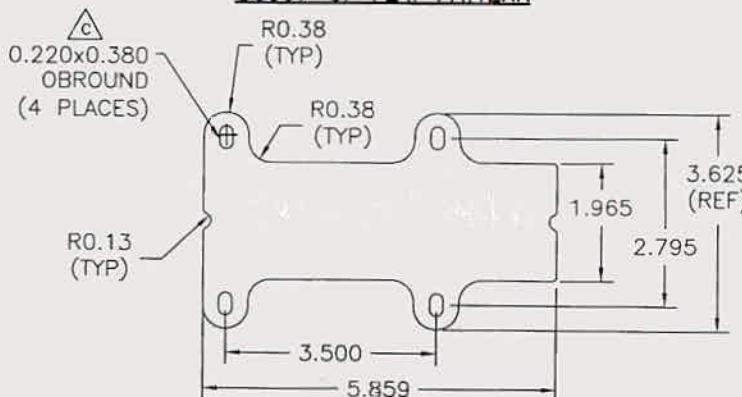


D3537-1/-3/-5/-7 WEARPAD NOTES

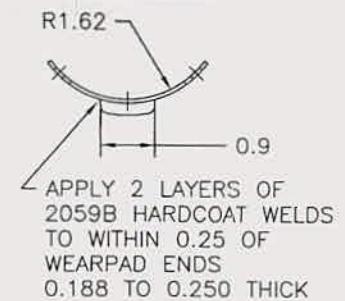
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

5036040
WORK ORDER
WITH-OUT NOTICE
SUBJECT TO AMENDMENT
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

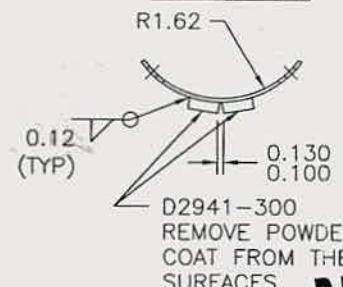
D3537-3F FLAT PATTERN



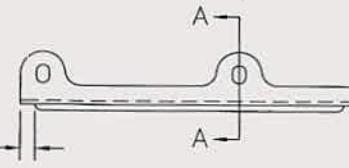
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



RELEASED
07-05-08 AF
per E&N

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. PORT HUENEMER, MD
CHECKED	PH	DRAWING NO. D3537
APPROVED	PH	REV. C
DATE	07.04.13	SHEET 1 OF 1
TITLE	WEARPAD	SCALE 1:2

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS HELD ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

